

Work Order ID 145101

Tuesday, May 03, 2016 1:50:00 PM

145101

Page 1

Item ID: D139-1012-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: AW139 High Capacity Cargo Net

Stop ***NS2***

Start Date: 5/6/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: MAY 03 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D139-1012-011	<u>A</u>								
110	Document Control	0.00							
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D139-1012-011								
120	Pick Kit	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.00							
Quality Control									

JUN 17 2016

DAS
27
9-89

DAS
9
9-89

chg 001

DAS
9
9-89

DAS
27
9-89

JUN 16 2016

DAS
9
9-89

①

16-06-27

DAS
9
9-89

PTO →

DQA:

Date:

06/07/08

QA Closed:

Date:

16/5893

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>145101</u> Part No. <u>D139-1012-011</u> NCR No. <u>16-5893</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>16-06-27</u>	Step #: <u>130</u>	QTY Effective: <u>1</u>	MRB (QSI042) Approval DAS <u>22</u> <u>16.07.04</u> 9-88																																																																	
Description Work Order Deviation		Disposition		Completed By																																																																
AN526-10212 doesn't exist 		Replace with AN526-103212 OPENED PAR 16-533		DAS <u>6</u> <u>16-01-04</u> 9-88																																																																
				Lead Hand / Supervisor Approval Verification DAS <u>9</u> 9-88 <u>16-06-30</u>																																																																
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OTHER :																																																																				

Work Order ID 145101***145101***

Page 2

Tuesday, May 03, 2016 1:50:00 PM

Item ID: D139-1012-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AW139 High Capacity Cargo Net

Start Date: 5/6/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

140

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D139-1012-011

Location: _____

PPP Rev: _____

DAS
27
8-89

JUN 27 2016

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

GA 6/27/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
03/04/18								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

Picklist Print

Tuesday, May 03, 2016 1:50:03 PM

Page 1

Work Order ID: 145101

145101

Parent Item: D139-1012-011

D139-1012-011

Parent Item Name: AW139 High Capacity Cargo Net

Start Date: 5/6/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.04.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D139-1012-041		Manufactured	No				Each	0.0000		1			
D139-1012-041									**	1347009			DAS 27 9-89
AW139 Cargo Net Assembly													
D5320-043		Manufactured	No				Each	0.0000		7			
D5320-043									**	145154			DAS 6 27 9-89
D-Ring Assembly													
D5339-1		Manufactured	No				Each	50.0000		4			
D5339-1									**				DAS 6 27 9-89
Carabiner Clip													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST162	50					4			
				144002	50								
D5397-1		Manufactured	No				Each	6.0000		4			
D5397-1									**				DAS 6 27 9-89
D Ring													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST164	6					4			
				143978	6								
D5408-1		Manufactured	No				f	0.0000		1			
D5408-1									**	145162			DAS 6 27 9-89
Suspension Rope													
D5409-1		Manufactured	No				Each	0.0000		2			
D5409-1									**	145164			DAS 6 27 9-89
Placard													
D5409-3		Manufactured	No				Each	0.0000		2			
D5409-3									**	145165			DAS 6 27 9-89
Placard													

JUN 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Tuesday, May 03, 2016 1:50:03 PM

Page 2

Work Order ID: 145101

Parent Item: D139-1012-011

Parent Item Name: AW139 High Capacity Cargo Net

145101

D139-1012-011

Start Date: 5/6/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

AN526-10R12

1032 R12

DAS

22

9-89

Purchased

No

Each

0.0000

4

AN526-10R12

Screw

AN970-3

Purchased

No

Each

223.0000

4

AN970-3

Washers

DAS

9

9-89

Location

Loc Qty

Loc Code

ST260a

198

m129630

198

ST321

25

m128057

25

MS21059L3

Purchased

No

Each

163.0000

2

MS21059L3

Nut Plate

DAS

9

9-89

Location

Loc Qty

Loc Code

CA

8

M129682

8

GA

18

M133990

18

ST301

111

M134055

15

M134257

50

M134509

46

ST303

26

M133016

26

MS24665-136

Purchased

No

Each

71.0000

7

MS24665-136

Cotter Pins

DAS

9

9-89

Location

Loc Qty

Loc Code

ST289

71

2421

71

Tuesday, May 03, 2016 1:50:03 PM

Shop Packet Print

JUN 16 2016 Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Work Order ID 145101

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145101

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Item ID: D139-1012-011

Revision ID:

Item Name: AW139 High Capacity Cargo Net

Start Date: 5/6/2016 Start Qty: 1.00

Required Date: 6/10/2016 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

1
1

Approvals: Process Plan: MCS Date: MAY 03 2016 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D139-1012-011	A								
110	Document Control	0.00							
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D139-1012-011 chg 001								
120	Pick Kit	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.00							
Quality Control									

JUN 15 2016

MCS JUN 15 2016

4.0 WEIGHT AND BALANCE

The following weight and balance is for the Dart installation. The weight and balance of parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D139-1012-011 CARGO NET INSTALLATION	28.8 lb 13.0 kg	±0.0 in ±0.0 m	±0.0 in lb ±0.0 m kg	280 in 7.11 m	8064 lb in 92.4 kg m

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D139-1012-011	CARGO NET INSTALLATION
1	D139-1012-041	CARGO NET ASSY
7	D5320-043	D-RING ASSEMBLY
4	D5339-1	CARABINER CLIP
4	D5397-1	D-RING
1	D5408-1	SUSPENSION ROPE
2	D5409-1	PLACARD
2	D5409-3	PLACARD
4	AN526-TOR12	SCREW
4	AN970-3	WASHER
2	MS21059L3	NUT PLATE
7	MS24665-136	COTTER PIN

AN526-1032R12